



INDUSTRIAL

Double Flute HSS 'O' Flute Straight Router Bits

Material	Feed Rate (Inch/Min)		Speed Rate (RPM)	
	#HSS1601 1/4"	#HSS1602 1/4"	#HSS1601 1/4"	#HSS1602 1/4"
Soft & Hard Plastics	120"	100"	15,000	12,500

Simple Machining Calculations:

To find **RPM**: $SFM \times 3.82 / \text{diameter of tool}$

To find **SFM***: $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate**: $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

To find **Chip Load**: $\text{IPM} / (\text{RPM} \times \# \text{ of Flutes})$

SFM* Surface feet per minute

Depth of Cut: 1 x D Use recommended feed rate

2 x D Reduce feed rate by 25%

3 x D Reduce feed rate by 50%